

Work Order ID **56518**

March 1, 2010 8:10:49 AM



Page 1

Item ID: D4010-1

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 3/01/10 Start Qty: 3.00



Cust Item ID:

Required Date: 3/01/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4010

C

100



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to fit frame size

110



THERMOFORMING MACHINE

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D4010-1 and Folio FTA067 using tool DT 9540
Dwg. Rev. C
Folio Rev. _____

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

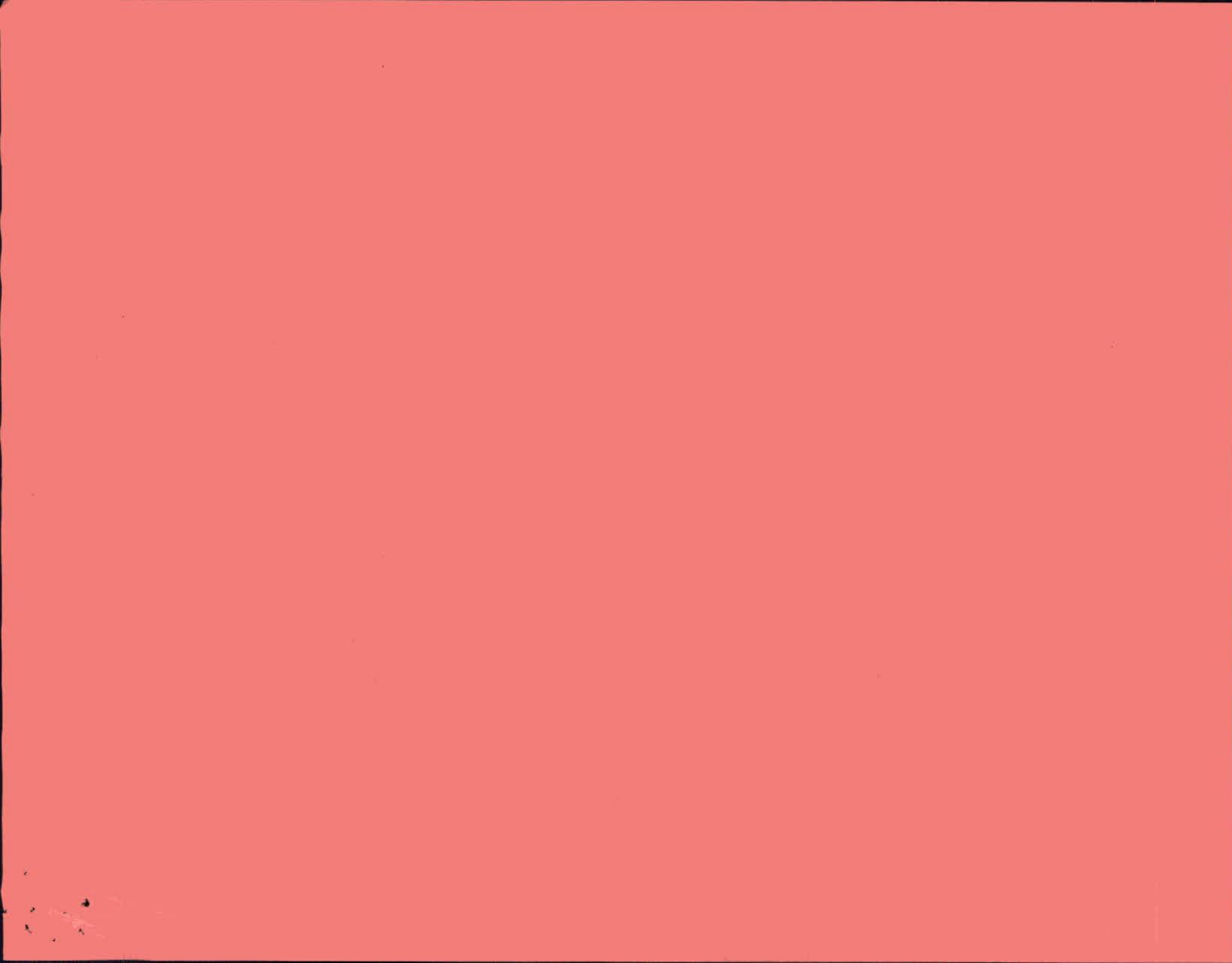
0.00

Quality Control

Visually inspect for proper formation of each part

B
10/02/25
X
Day Sweeney 10/02/27
19:45
6:45 AM 10/03/01
B
10/03/01
XY

B
10/03/01
XY



Work Order ID 56518

March 1, 2010 8:10:50 AM



Page 2

Item ID: D4010-1

Revision ID:

Item Name: Bearpaw

Start Date: 3/01/10

Start Qty: 3.00

Required Date: 3/01/10

Req'd Qty: 3.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

DL 10/03/01 (x4)

140



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

1-Trim & Drill to Finished Dimensions as per dwg D4010-1

2- Use wearplate jig DT9542 to transfer drill holes in bearpaw as per dwg and use 0.375" unibite to open holes to finish size.

3- Deburr

BB 10/03/01 (x4)

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

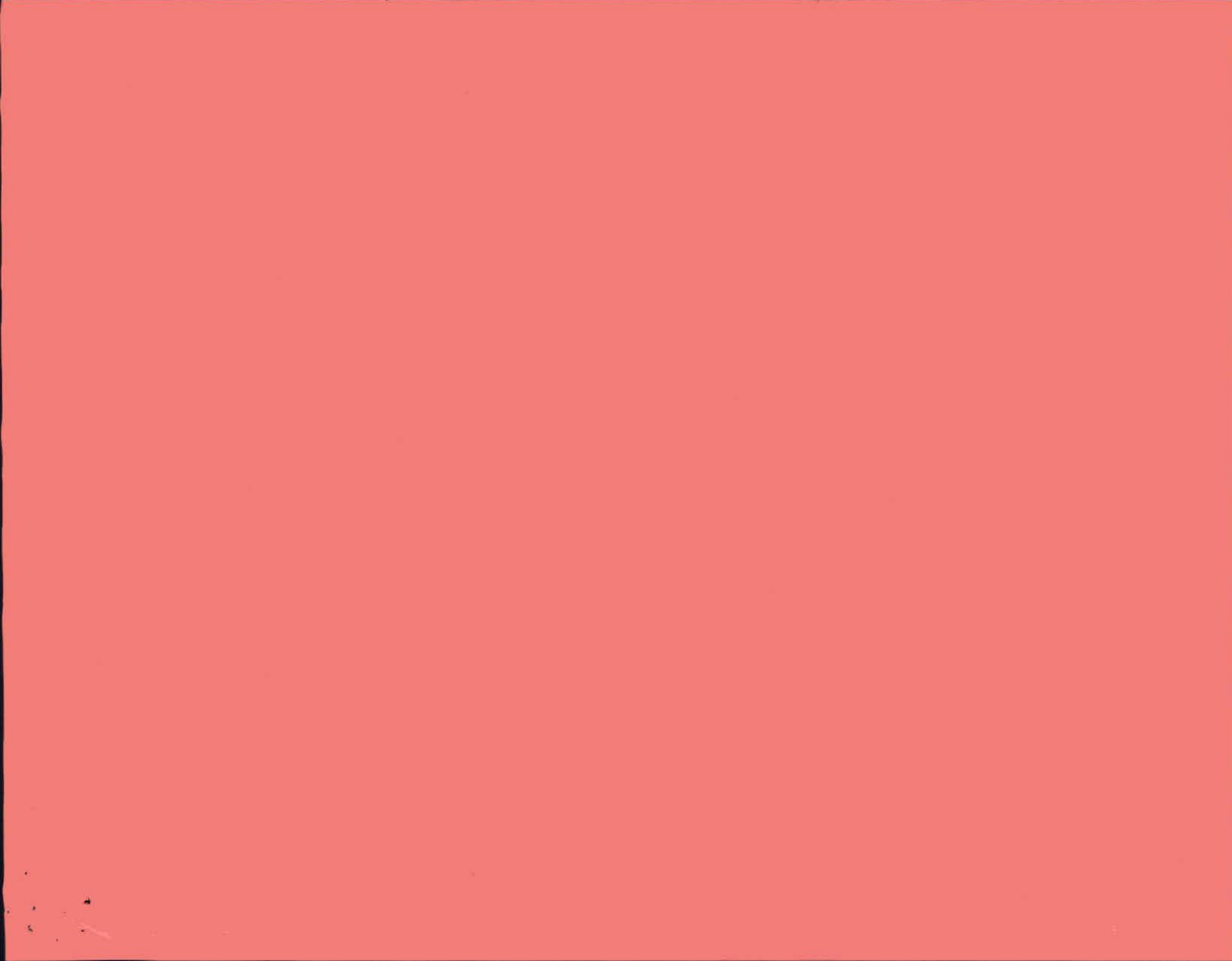
0.00

Memo

0.00

Check dimensions to ensure conformity to drawing tolerances.

BB 10/03/01 (x4)



Work Order ID 56518

March 1, 2010 8:10:50 AM



Page 3

Item ID: D4010-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 3/01/10

Start Qty: 3.00



Cust Item ID:

Required Date: 3/01/10

Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

Part # 1 - 2 good.



QC

Memo

0.00

Part # 2 - Annulated for testing.

Part # 3 - good.

Part # 4 - not annulated for testing.

Quality Control

4

10-03-02

PTO →

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

SEE W/O NCR FOR DISPOSITION

10/04/15

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10-03-02

AUTH

RELEASED

DATE

W

10-04-14
(H)

PULL on
R00324AAR



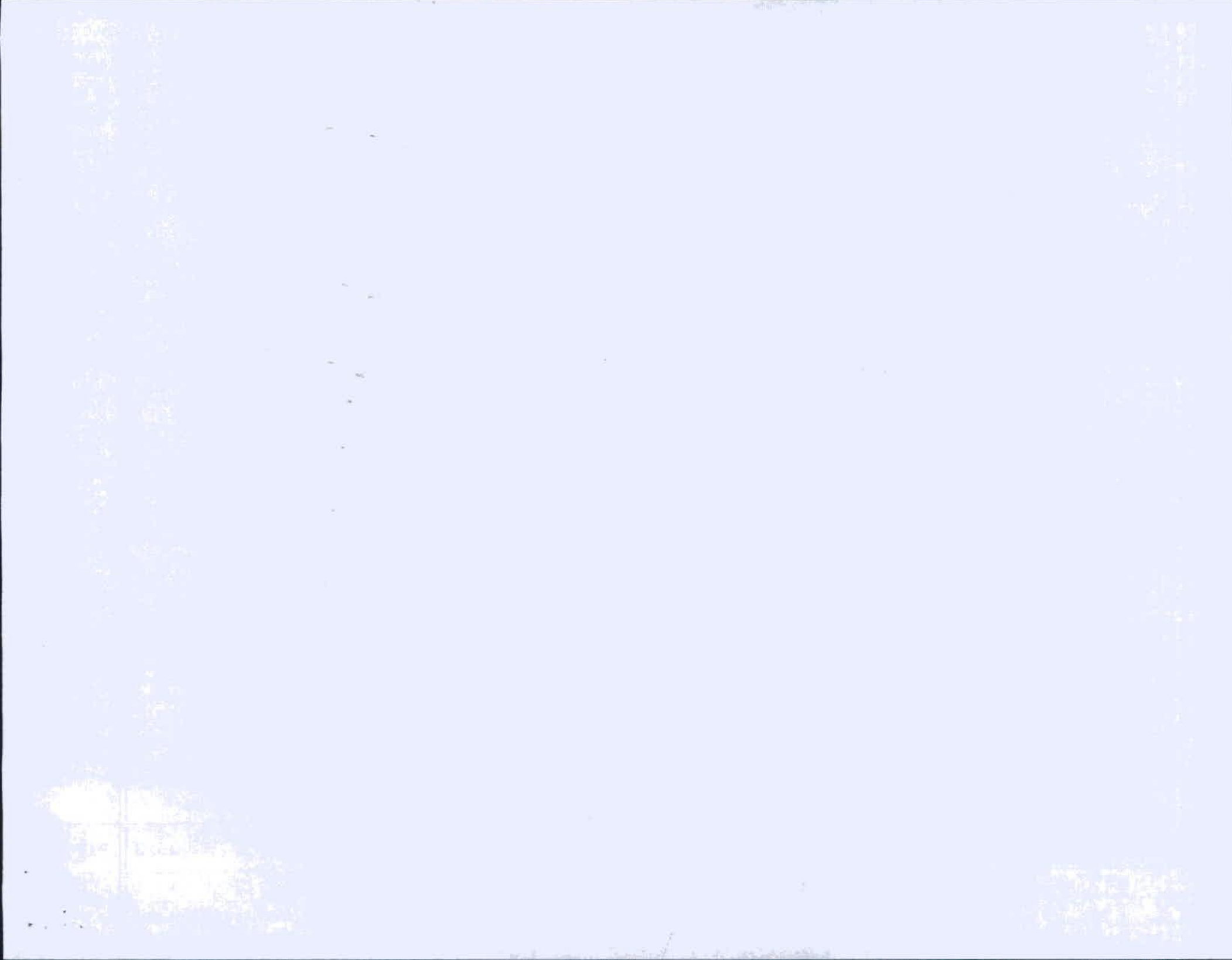
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4610-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 7 Date: 10/04/08
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>56518</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/07	160.	MOULD BEING MODIFIED. PARTS DO NOT CONFORM TO CURRENT MOULD CONFIGURATION.	<u>JSUM</u>	2 - PARTS CONSUMED FOR TESTING. 2 - PARTS SCRAP - DO NOT REPLACE	<u>JSUM</u> 10/04/07	<u>JSUM</u> 10/04/07	<u>JSUM</u>	<u>JSUM</u>

NOTE: Date & initial all entries



Picklist Print

March 1, 2010 8:10:49 AM

Page 1

Work Order ID: 56518



Parent Item: D4010-1



Parent Item Name: Bearpaw

Start Date: 3/01/10

Required Date: 3/01/10

Comments: IPP RevA: New issue DD verified by:EC
UNDER REVIEW 23/02/10 DL

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M-ALXTRAB-S300		Purchased	No			100	sf	795.4833	22.4337			



Alextra ET 0.300 sheet



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

795.4833

113108

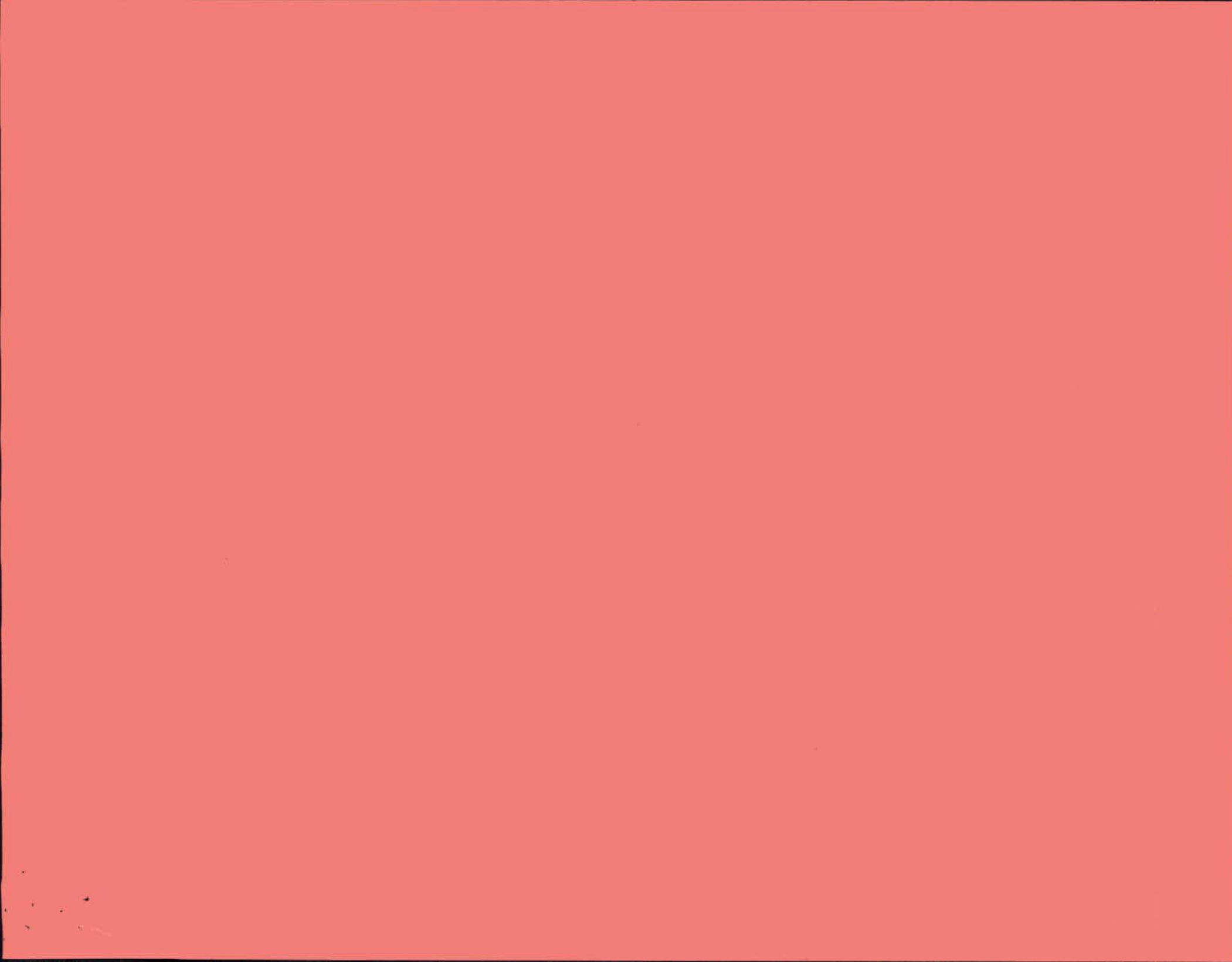
795.4833

4

BB

10/03/01

299116



DART AEROSPACE LTD		Work Order: 56518
Description: D 4010-1 BEARPAW		Part Number: D 4010-1
Inspection Dwg: D 4010	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: 10/03/01

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.175	Mio	0.223	✓			
0.210	Mio	0.293	✓			
27.00	± .50	26.720	✓			
2.34	± .25	2.25	✓			
23.25		23.25	✓			

Measured by: JB

Date: 10/03/01

Audited by: Sh

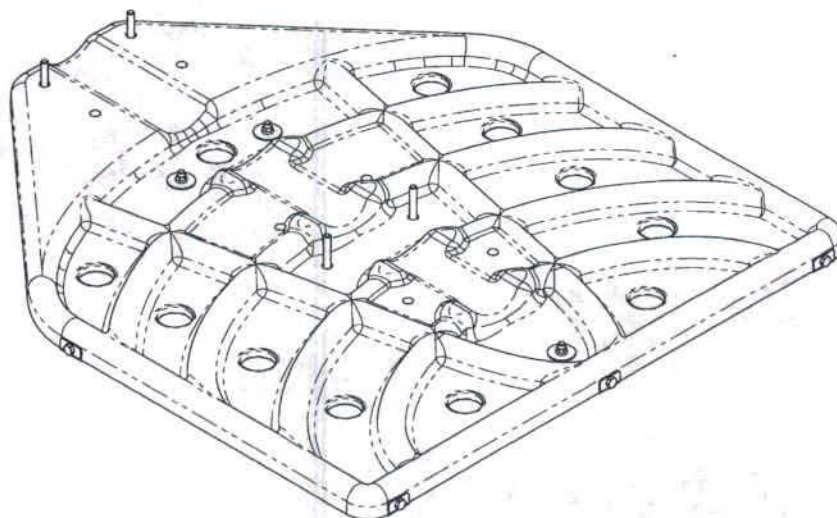
Date: 10/03/01

Prototype Approval: [Signature]

Date: [Signature]

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	





D4010-041 BEARPAW ASSEMBLY (407)

56518

RELEASED
2009-11-26
MT

C	OPTIMIZED DESIGN BASED ON FUNCTIONALITY AND TO EASE MANUFACTURING	MB	09.11.10
B	REDESIGNED, ADDED PROVISIONS FOR COMPATIBILITY WITH OEM SKIDTUBES/SADDLES; REDEFINED SOME TOLERANCE	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.10		

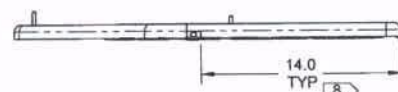
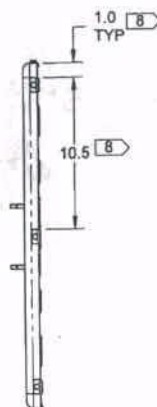
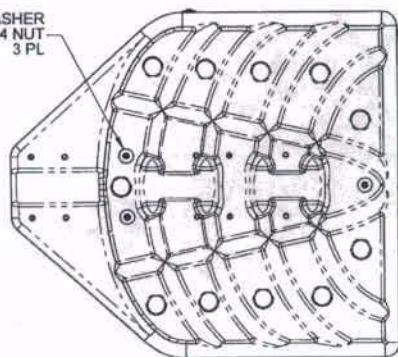
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4010** REV. C
TITLE **BEARPAW (407)** SCALE NTS

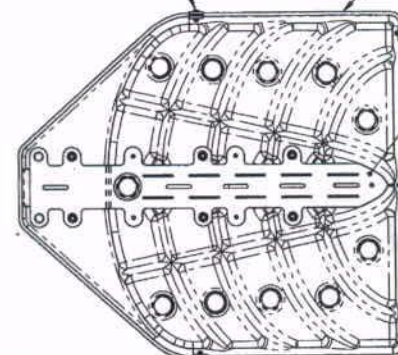
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D3456-1 WASHER
MS21043-4 NUT
3 PL



AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT



AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4010-041 BEARPAW ASSEMBLY (407)

D4010-1
BEARPAW

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4013-041 WEARPLATE
ASSEMBLY

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4010-041	BEARPAW ASSEMBLY (407)
3	3	D3456-1	WASHER
4	1	D4010-1	BEARPAW
5	1	D4013-041	WEARPLATE ASSEMBLY
6	5	D4015-041	WEARBAR
21	5	AN3C5A	BOLT
22	5	MS21043-3	NUT
23	3	MS21043-4	NUT

56518

RELEASED
2009-11-24

D4010-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9.41 lbs
- 8) LOCATE D4015-041 (ITEM 5) AS SHOWN AND TRANSFER DRILL
Ø0.191" HOLE FROM D4015-041 TO D4010-1 BEARPAW AND FASTEN
USING PRESCRIBED HARDWARE.
- 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. C
MFG. APPR.	1	D4010	SHEET 2 OF 3
APPROVED	1	TITLE	SCALE
DE APPR.	1	BEARPAW (407)	NTS
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